

Work Order ID: ~~76164~~

76164

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Monday, November 07, 2011 12:57:46 PM

Item ID: ~~D3257-1~~

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fitting

Start Date: 11/7/2011 Start Qty: 6.00 *10.0* ***6***

Cust Item ID:

Required Date: 11/16/2011 Req'd Qty: 6.00 ***6***

Customer:

Reference:

Approvals: Process Plan: */* Date: *11-07* Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3257	Rev A1

100		0.00							
100	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank: 0.500" x 0.500" x 1.180" long Bar								

11/12/14

10

110		0.00							
110 <i>perch</i>	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA420 and Dwg D32571-Debur2- *****FINISH TAPPING PARTS BY HAND AS PER DWG D3257*****								

issue Pro to Archer. P/O: 15679

Machine as per dwg D 3257 Rev A

120		0.00							
120	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

*Rec'd + inspect for transit damage -
attached COC to W/O*

11/12/14 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76164

76164

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Monday, November 07, 2011 12:57:46 PM

Item ID: D3257-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fitting
 Start Date: 11/7/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 11/16/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 <i>Sm 12-8-02</i>	<i>DAS 16 2-8 1702/4</i>			<i>9</i>			<i>710 →</i>
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <i>ST3b</i> Memo	0.00 0.00				<i>9x</i>			<i>SP 12-8-8</i>
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>MCS 12108123</i> <i>121208.24</i>

W/O: 76164		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

See Pink NCR
12-1756
Supplier fault.
Archer Precision

Part No: D3257-1 PAR #: _____ Fault Category: Supplier NCR: ☒ Yes ☐ No DQA: _____ Date: _____

Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/08/07	110	Qty of Part scrap by Supplier Re. Supplier	DAS 16 9-83 067017 12/08/07	Reduce Reduce by -1 See attached email from Supplier on this issue	n/a	DAS 16 9-83 12/08/07	DAS 16 9-83 067017 12/08/07	DAS 16 9-83 12/08/07

41.59 (x303.84 on w/o 15108)

NOTE: Date & initial all entries

Picklist Print

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Monday, November 07, 2011 12:57:51 PM

Work Order ID: 76164

76164

Parent Item: D3257-1

D3257-1

Parent Item Name: Fitting

Start Date: 11/7/2011

Required Date: 11/16/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: A04.04.14New issueKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
303B0.500X0.500		Purchased	No			100	f	8.7609	0.1092	0.689684			

~~M303B0.500X0.500*~~
AISI 303 Bar .500 x .500

**

Location

Loc Qty

Loc Code

MAT050

8.7609

111571

8.7609

1.2 f 11/2/13

D 3257-1 P

x 10

11/2/12 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

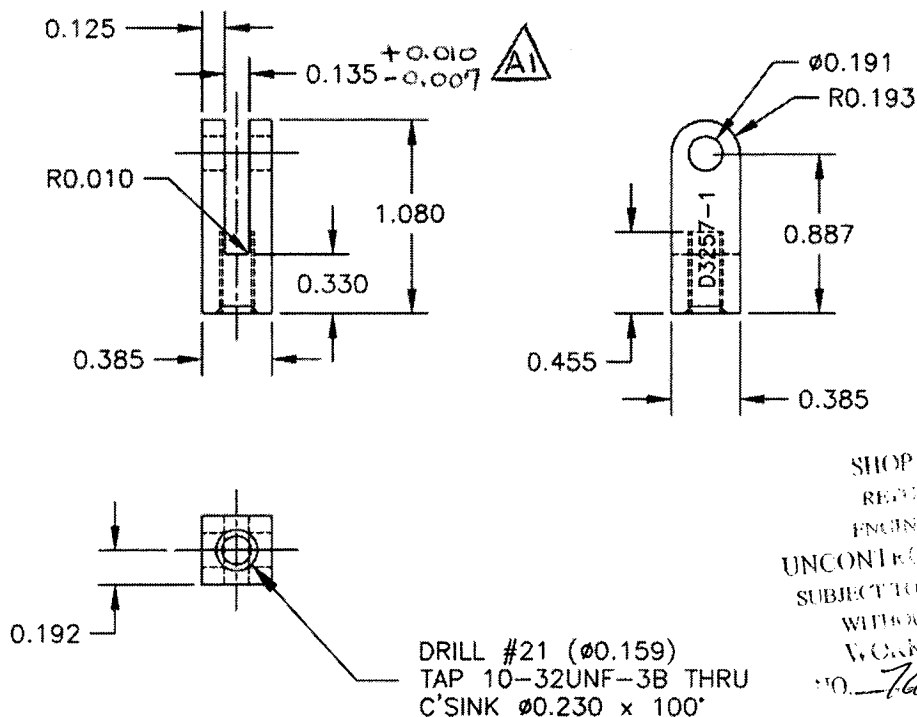
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3257	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE FITTING	SCALE 1:1
A	04.01.27	NEW ISSUE	
AI	04.12.14	ADD TOLERANCE	

RELEASED
04.04.05



SHOP COPY
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SUBJECT TO AND MARKED
WITHOUT NOTICE
WORK ORDER
NO. 76169

R 11/11-07

D3257-1 FITTING

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: AISI 303 SS, BAR (REF DART SPEC. M303B0.500X0.500)
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE DART P/N AS SHOWN

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



2228 Gladwin Cresent
Ottawa, Ontario
K1B 4S6
Phone # 613-899-2405

Packing Slip

Date	Invoice #
7/31/2012	201

Ship To
Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. No.	Ship	Via	FOB	Project
15679	7/31/2012	Federal Express	Archer	

Qty	Item Code	Description
9	Sales	D3257-1P Fitting HST (ON) on sales



2228 Gladwin Cres.
Ottawa, Ont.
K1B 4S6

Telephone (613) 899-2405
Fax (613) 226-1719

Certificate of Compliance

To
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury Ont.
K6A 1K7

Po Number	Part Number	Quantities
15679	D3257-1P	9

It is hereby certified that all articles mentioned above are in conformance with the requirements, specification and drawings as listed on customer purchase order number, 15679 issued by Dart Aerospace Inc.

Alex Mazerolle
President
Archer Precision Inc.
1393 Major Road,
Orleans Ontario
K1E 1H3



Inspection Report

Customer Name Dart Aerospace		QTY 10	DWG # D3257-1	REV. A	Part Name FITTING	Date JAN 27/2012	Lot#	Job # 477-10
Page 1 of	Inspection Interval	Special Notes						

Item #	DWG. Dim	Tolerance	Operator	QA First Off		QA Final		2		3	4	5	6	7	8	9	10
			First Off	A	R	A	R										
	Rev	A	✓	✓		✓											
	MAT	303 SS	✓	✓		✓											
	SUB	-															
	Deburr	YES	✓	✓		✓											
1	.125	±.005	.126	✓		✓		.124	.124	.128	.123	.127	.125	.122	.127		
2	.135	+0.01/-0.007	.134	✓		✓		.139	.138	.139	.141	.140	.139	.142	.140		
3	R.01	±.005	.01	✓		✓		PP	PP	PP	PP	PP	PP	PP	PP		
4	1.080	±.005	1.079	✓		✓		1.081	1.081	1.082	1.081	1.081	1.081	1.081	1.081		
5	.330	±.005	.330	✓		✓		.329	.329	.327	.329	.327	.330	.329	.330		
6	.385	±.005	.385	✓		✓		.384	.384	.385	.384	.385	.385	.384	.385		
7	.192	±.005	.190	✓		✓		.191	.191	.192	.191	.192	.191	.191	.191		
8	10-32	-	✓	✓		✓		✓	✓	✓	✓	✓	✓	✓	✓		
9	Ø.230	±.005	.226	✓		✓		.226	.228	.228	.230	.229	.229	.229	.229		
10	100°	±.005	100°	✓		✓		100	100	100	100	100	100	100	100°		
11	.385	±.005	.384	✓		✓		.385	.386	.386	.385	.386	.386	.386	.385		
12	.455	±.005	.458	✓		✓		.455	.460	.458	.460	.460	.460	.460	.459		
13	.887	±.005	.885	✓		✓		.885	.885	.885	.886	.885	.885	.886	.886		
14	R.193	±.005	.1923	✓		✓		PP	PP	PP	PP	PP	PP	PP	PP		
15	Ø.191	±.005	.191	✓		✓		.191	.191	.191	.191	.191	.191	.191	.191		

Jean-Luc Menard

From: alex@archerprecision.ca
Sent: Tuesday, August 07, 2012 8:33 AM
To: Jean-Luc Menard
Subject: Re: D3257-1

Good morning Jean-Luc,

We scraped it, and one of my guys destroyed it and threw it out. He didn't realize we keep the scrap parts and send them back to you.

How did that large quote for the lath work look?

I am on holidays this week but I am checking emails and if you need anything, just let me know.

Thanks,

Alex

Sent from my BlackBerry® phone powered by Koodo Mobile®.

From: "Jean-Luc Menard" <jmenard@dartaero.com>
Date: Tue, 7 Aug 2012 07:48:46 -0400
To: Alex Mazerolle <Alex@archerprecision.ca>
Subject: D3257-1

Hi Alex,

The P.O was for a qty of 10 and we received 9.

Could you tell me what happened to the 10 th so I can attach to the w/o.(QC is asking).

Thx

JL

Jean-Luc Menard

Production Engineering Coordinator



DART AEROSPACE

1270 Aberdeen Street

Hawkesbury Ontario

Canada K6A 1K7

Tel:(613)632-5200 Ext 227

jmenard@dartaero.com



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